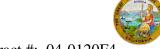
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-004297

Address: 333 Burma Road **Date Inspected:** 17-Oct-2008

City: Oakland, CA 94607

OSM Arrival Time: 630 **Project Name:** SAS Superstructure **OSM Departure Time:** 1530 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Sun Wei **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** OBG

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

OBG Sub-Assembly Bay 1

This QA inspector monitored ZPMC performing MT inspection on DP109-001 a total of 224 tacks were welded ZPMC discovered 115 linear indications 111 of which were reported as cracks. After removal by grinding and additional MT inspection in order to determine if all relevant indications were removed, ZPMC proceeded to weld with GMAW on the gantry machine number 2. This QA inspector observed no tacks were rewelded prior to the gantry welding process even though as many as seven consecutive tacks were removed on individual welds.

Tacks on DP487-001 were being ground in order to perform MT inspection.

DP380-001 was being fit-up during this shift.

Summary of Conversations:

No relevant conversations spoken on this date.

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Dautermann, Peter (707) 552-7715, who represents the Office of Structural

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Materials for your project.

Inspected By: McClendon, Timothy Quality Assurance Inspector

Reviewed By: Cuellar,Robert QA Reviewer